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ASAP

**647.7501**  
**Job Sheet 201438**



**Part No:** 647.7501

**Job Qty:** 2 pcs

**Part Name:** Lower Cutter Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 10/3/19

**Job Tracking No:**

**Due Date:** 10/18/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG REV A IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op<br>No | Operation              | Qty   | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign-off    |
|----------|------------------------|-------|------------|-------------|--------------|------------|-----------------------|-----------|-------------|
|          |                        |       |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |             |
| 110      | Packaging 1 - Pick Kit | 2 pcs |            | 10/18/19    | 0.00         | 0.00       | Packaging 1 - 1       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 2       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 3       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 4       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 5       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 6       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 7       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 8       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 9       |           | OCT 04 2019 |
|          |                        |       |            |             |              |            | Packaging 1 - 10      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 11      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 12      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 13      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 14      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 15      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 16      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 17      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 18      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 19      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 20      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 21      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 22      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 23      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 24      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 25      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 26      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 27      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 28      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 29      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 30      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 31      |           |             |

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|     |                             |       |          |           |                        |             |
|-----|-----------------------------|-------|----------|-----------|------------------------|-------------|
| 120 | Small Fab - 2 - B4B         | 2 pcs | 10/18/19 | 0.00 2.56 | Packaging 1 - 32       |             |
|     |                             |       |          |           | Packaging 1 - 33       |             |
|     |                             |       |          |           | Packaging 1 - 34       |             |
|     |                             |       |          |           | Packaging 1 - 35       |             |
|     |                             |       |          |           | Packaging 1 - 36       |             |
|     |                             |       |          |           | Small Fab - 1 - B4B    |             |
|     |                             |       |          |           | Small Fab - 2 - B4B    |             |
|     |                             |       |          |           | Small Fab - 3 - B4B    |             |
|     |                             |       |          |           | Small Fab - 4 - B4B    | OCT 08 2019 |
|     |                             |       |          |           | Small Fab - 5 - B4B    |             |
| 130 | QC 5                        | 2 pcs | 10/18/19 | 0.00 0.00 | Small Fab - 6 - B4B    |             |
|     |                             |       |          |           | Small Fab - 7 - B4B    |             |
|     |                             |       |          |           | Small Fab - 8 - B4B    |             |
|     |                             |       |          |           | QC 5 - 10              |             |
|     |                             |       |          |           | QC 5 - 12              |             |
|     |                             |       |          |           | QC 5 - 17              |             |
|     |                             |       |          |           | QC 5 - 18              |             |
|     |                             |       |          |           | QC 5 - 19              |             |
|     |                             |       |          |           | QC 5 - 22              |             |
|     |                             |       |          |           | QC 5 - 24              |             |
|     |                             |       |          |           | QC 5 - 3               |             |
|     |                             |       |          |           | QC 5 - 43              |             |
|     |                             |       |          |           | QC 5 - 49              |             |
|     |                             |       |          |           | QC 5 - 51              |             |
|     |                             |       |          |           | QC 5 - 58              |             |
|     |                             |       |          |           | QC 5 - 68              |             |
|     |                             |       |          |           | QC 5 - 9               |             |
|     |                             |       |          |           | QC 5 - 50              |             |
|     |                             |       |          |           | QC 5 - 30              |             |
|     |                             |       |          |           | QC 5 - 40              | OCT 11 2019 |
|     |                             |       |          |           | QC 5 - 61              | DAS 40      |
|     |                             |       |          |           | QC 5 - 81              | 9-89        |
| 140 | Packaging 3-1 - Stock - B4B | 2 pcs | 10/18/19 | 0.00 0.00 | QC 5 - 10              |             |
|     |                             |       |          |           | QC 5 - 12              |             |
|     |                             |       |          |           | QC 5 - 17              |             |
|     |                             |       |          |           | QC 5 - 18              |             |
|     |                             |       |          |           | QC 5 - 19              |             |
|     |                             |       |          |           | QC 5 - 22              |             |
|     |                             |       |          |           | QC 5 - 24              |             |
|     |                             |       |          |           | QC 5 - 3               |             |
|     |                             |       |          |           | QC 5 - 43              |             |
|     |                             |       |          |           | QC 5 - 49              |             |
|     |                             |       |          |           | QC 5 - 51              |             |
|     |                             |       |          |           | QC 5 - 58              |             |
|     |                             |       |          |           | QC 5 - 68              |             |
|     |                             |       |          |           | QC 5 - 9               |             |
|     |                             |       |          |           | QC 5 - 50              |             |
|     |                             |       |          |           | QC 5 - 30              |             |
|     |                             |       |          |           | QC 5 - 40              |             |
|     |                             |       |          |           | QC 5 - 61              |             |
|     |                             |       |          |           | QC 5 - 81              |             |
|     |                             |       |          |           | Packaging 3 - 1 - B4B  |             |
|     |                             |       |          |           | Packaging 3 - 2 - B4B  |             |
|     |                             |       |          |           | Packaging 3 - 3 - B4B  |             |
|     |                             |       |          |           | Packaging 3 - 4 - B4B  |             |
|     |                             |       |          |           | Packaging 3 - 5 - B4B  |             |
|     |                             |       |          |           | Packaging 3 - 6 - B4B  |             |
|     |                             |       |          |           | Packaging 3 - 7 - B4B  |             |
|     |                             |       |          |           | Packaging 3 - 8 - B4B  |             |
|     |                             |       |          |           | Packaging 3 - 9 - B4B  |             |
|     |                             |       |          |           | Packaging 3 - 10 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 11 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 12 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 13 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 14 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 15 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 16 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 17 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 18 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 19 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 20 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 21 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 22 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 23 - B4B | PC SKool    |
|     |                             |       |          |           | Packaging 3 - 24 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 25 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 26 - B4B |             |
|     |                             |       |          |           | Packaging 3 - 27 - B4B |             |

|                |       |          |           |                 |                        |             |
|----------------|-------|----------|-----------|-----------------|------------------------|-------------|
|                |       |          |           |                 | Packaging 3 - 28 - B4B |             |
|                |       |          |           |                 | Packaging 3 - 29 - B4B |             |
|                |       |          |           |                 | Packaging 3 - 30 - B4B |             |
|                |       |          |           |                 | Packaging 3 - 31 - B4B |             |
|                |       |          |           |                 | Packaging 3 - 32 - B4B |             |
|                |       |          |           |                 | Packaging 3 - 33 - B4B |             |
|                |       |          |           |                 | Packaging 3 - 34 - B4B |             |
|                |       |          |           |                 | Packaging 3 - 35 - B4B |             |
|                |       |          |           |                 | Packaging 3 - 36 - B4B |             |
| 150 QC 21 - SA | 2 pcs | 10/18/19 | 0.00 0.00 | QC 21 - SA - 21 |                        |             |
|                |       |          |           | QC 21 - SA - 70 |                        | OCT 15 2019 |
|                |       |          |           | QC 21 - SA - 53 |                        |             |

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. S173363 exp: 12/20.  
 Descriptions: 130 - (QC5- Inspect part completeness to step on W/O)  
 140 - (Identify as per dwg & Stock Location: \_\_\_\_\_), \*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV\*\*\*  
 150 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item   | Component Name                  | Quantity      | Operation                  | Container |
|---------------|---------------------------------|---------------|----------------------------|-----------|
| 646.3015      | Blade CCK102                    | 4 pcs (2 ea)  | 110-Packaging 1 - Pick Kit | 8105905   |
| 647.7601      | Lower Deflector Assembly CCK065 | 2 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 8161557   |
| 647.7810      | Bracket A CCK077A               | 2 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 8115101   |
| 647.7811      | Bracket B CCK077A               | 2 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 8116688   |
| 647.7813      | Center Plate, Lower CCK114      | 2 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 8107255   |
| 647.7814      | Fwd Bracket CCK114              | 2 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 8112691   |
| 647.7815      | Fwd Bracket CCK122A             | 2 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 8113568   |
| 647.7816      | Aft Bracket CCK122A             | 2 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 8113671   |
| 647.7817      | Aft Bracket CCK115              | 2 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 8118838   |
| MS21042L08    | Nut ST303                       | 26 Ea (13 ea) | 110-Packaging 1 - Pick Kit | 8205000   |
| MS21042L3     | Nut ST303                       | 6 Ea (3 ea)   | 110-Packaging 1 - Pick Kit | 8211583   |
| MS27039-08-19 | Screw GA015                     | 14 Ea (7 ea)  | 110-Packaging 1 - Pick Kit | 8204996   |
| MS27039-08-24 | Screw (MS27039-0824) GA015      | 12 Ea (6 ea)  | 110-Packaging 1 - Pick Kit | F121326-9 |
| MS27039-1-19  | Screw GA017                     | 6 Ea (3 ea)   | 110-Packaging 1 - Pick Kit | 8123643   |
| NAS1149F0332P | Washer (AN960-10L) ST262        | 12 Ea (6 ea)  | 110-Packaging 1 - Pick Kit | 8207709   |
| NAS1149FN832P | Washer (AN960-8) ST260A         | 52 Ea (26 ea) | 110-Packaging 1 - Pick Kit | 8207676   |

## Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 110-Packaging 1 - Pick Kit | 646.3015       | 4        | 9         | 0         |
|                            | 647.7601       | 2        | 2         | 0         |
|                            | 647.7810       | 2        | 31        | 0         |
|                            | 647.7811       | 2        | 33        | 0         |
|                            | 647.7813       | 2        | 38        | 0         |
|                            | 647.7814       | 2        | 13        | 0         |
|                            | 647.7815       | 2        | 39        | 0         |
|                            | 647.7816       | 2        | 38        | 0         |
|                            | 647.7817       | 2        | 37        | 0         |
|                            | MS21042L08     | 26       | 1,078     | 0         |
|                            | MS21042L3      | 6        | 3,295     | 0         |
|                            | MS27039-08-19  | 14       | 662       | 0         |
|                            | MS27039-08-24  | 12       | 104       | 0         |
|                            | MS27039-1-19   | 6        | 435       | 0         |
|                            | NAS1149F0332P  | 12       | 3,143     | 0         |
|                            | NAS1149FN832P  | 52       | 1,709     | 0         |

## Part Specifications

Specifications could not be found.



Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. \_\_\_\_\_

Job: \_\_\_\_\_

Part No. \_\_\_\_\_

### DISPOSITION

Rework ☐  
Scrap ☐  
Use-as-is ☐

### DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐  
Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐  
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐

Engineering ☐  
Water Jet ☐  
Supplier ☐  
Quality ☐

Date: \_\_\_\_\_

Sequence #: \_\_\_\_\_

QTY Affected: \_\_\_\_\_

MRB (QS1042)

### Description Work Order Deviation

### Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

### Root Cause

Operator ☐  
Manufacturing Process ☐  
Equip/Tooling ☐  
Handling/Preservation ☐  
Material ☐  
Product Improvement ☐  
Process Improvement ☐  
Human Factors ☐

### FAULT CATEGORY

Pressure/Forced ☐ Contamination ☐  
Bending ☐ Misaligned/off center ☐  
Crushing ☐ BOM/Route ☐  
Cracks ☐ Broken/Damage/Defect ☐  
Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐  
Marks/Chatter ☐ Drill Holes ☐  
Mislabeled ☐ Fit/Function ☐

Power Loss/Surge ☐  
Folio/Program ☐  
Grain Direction ☐  
Weld ☐  
Wrong Stock Pulled ☐  
Out of Sequence ☐  
Off-set/Set-up ☐

Positioned Wrong ☐  
Outside Tolerance ☐  
Drawing ☐  
Finish ☐  
Part Lost/Missing ☐  
Misread ☐

Other/Details: \_\_\_\_\_